

Date: Monday, 25/05/2009 3:29:38 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212 BASKET BASE ASS'Y LH
Job Number	: 48202B		
Estimate Number	: 11542		
P.O. Number	:	Part Number	: D3053041
This Issue	: 25/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3053 REVB
First Issue	: / /	Project Number	:
Previous Run	: 37413B	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>MF 09-05-25</u>	Due Date	: 01/06/2009
Comment	: Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J/RF Est Rev:D 08-08-29 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
	Comment: Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s) 304 SQ Tube.75x.75x.065W 1-Cut Rib from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. Batch: <u>M111432</u> 2-Drill holes in D3053-3 as per dwg D3053 PD 09.05.26	
✓ 2.0	D31661	Basket Hoop
	Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s) Basket Hoop Cut Qty. 5 D3166-1 Batch: <u>B47956</u> PD 09.05.26	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 1-Cut 5 D2235-3 FROM D3166-1 using DT8365 2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995 PD 09.05.26	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

4.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Pick:

Qty Part Number Description Batch

2 D2327-3 Bushing

B44365

PD 09-05-26

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

Qty Part Number Description Batch

2 D2232-3 Hinge plate

B46822

Pl 09-05-26

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket

B46086

Pl 09-05-26

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty Part Number

48sq.ft M304EX0.75-16F

Description

Expanded Metal

Batch

M1173 (10)

M11444 (8)

M11630 (32)

SAN 09-05-27

(1)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove all markings from material

2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

****Ensure ribs are positionned for LH****

Pl 09-05-27

PD 09-05-26

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Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9

VISUAL WELDING INSPECTION



09/05/28



Comment: VISUAL WELDING INSPECTION

09-05-28

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/05/28

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 11:00 AM 1ST

FINISH TIME: 4:00 PM 11:30 AM

ZN

11:45 start time
400°F temp oven

12:15 finish time

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/05/28

1

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

48502

9/5/29

10

SP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/29

Job Completion



MF
09-05-29

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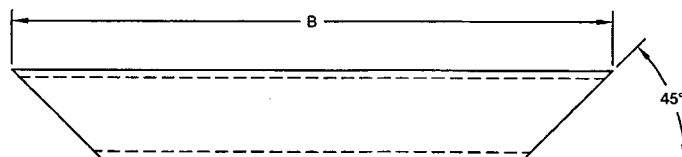
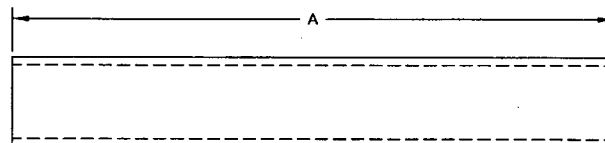
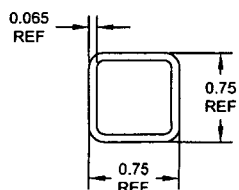
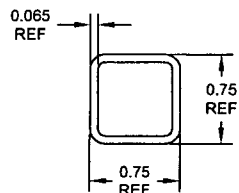
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PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



B

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

48202B

RELEASED

B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO 'B' FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	08.07.02	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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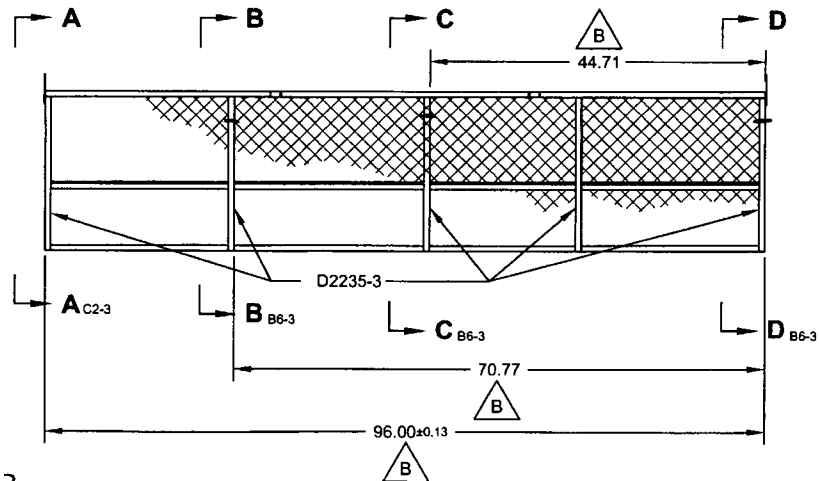
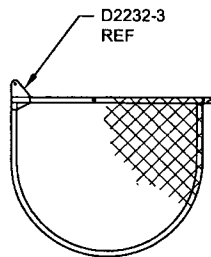
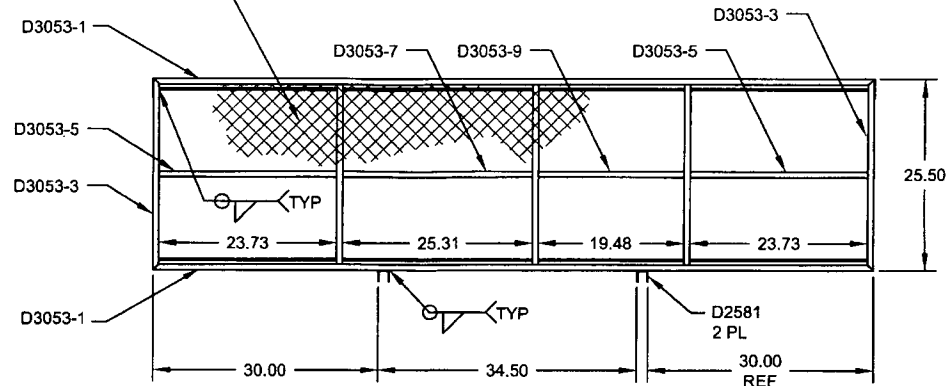
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SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME



#4820213

RELEASED
08.08.21/11/12

D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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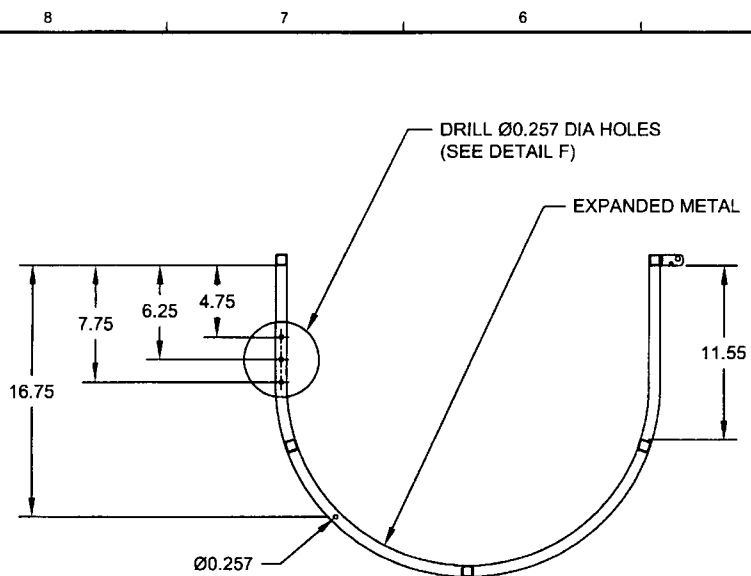
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

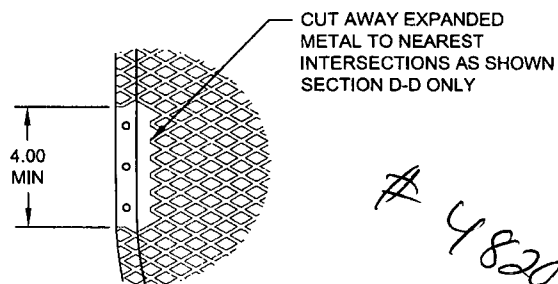
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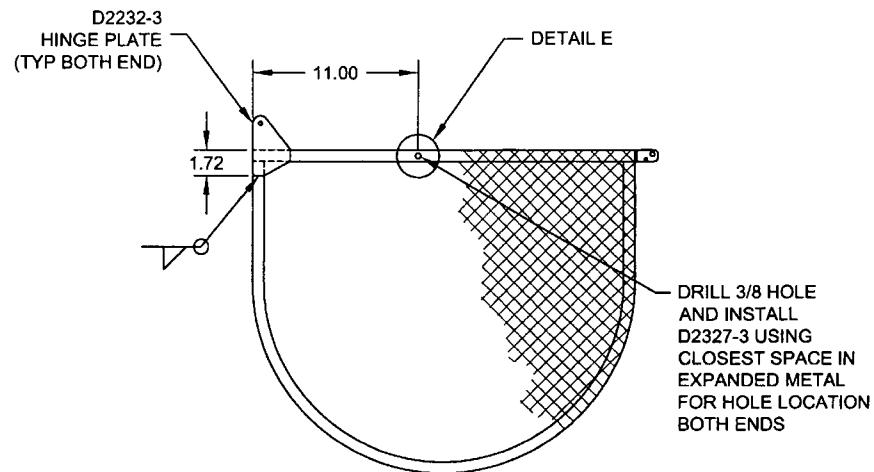


SECTION B-B_{B5-2}
SECTION C-C_{B4-2}
AND SECTION D-D_{B3-2}
RIB DETAIL

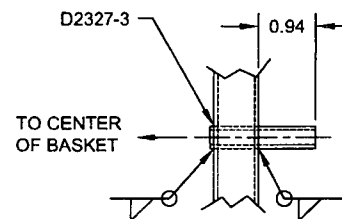


DETAIL F
SCALE NONE

4820210



SECTION A-A_{B6-2}
SPACER DETAIL



DETAIL E
SCALE 4X

RELEASED
08 05 21 1148

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3053	SHEET 3 OF 3
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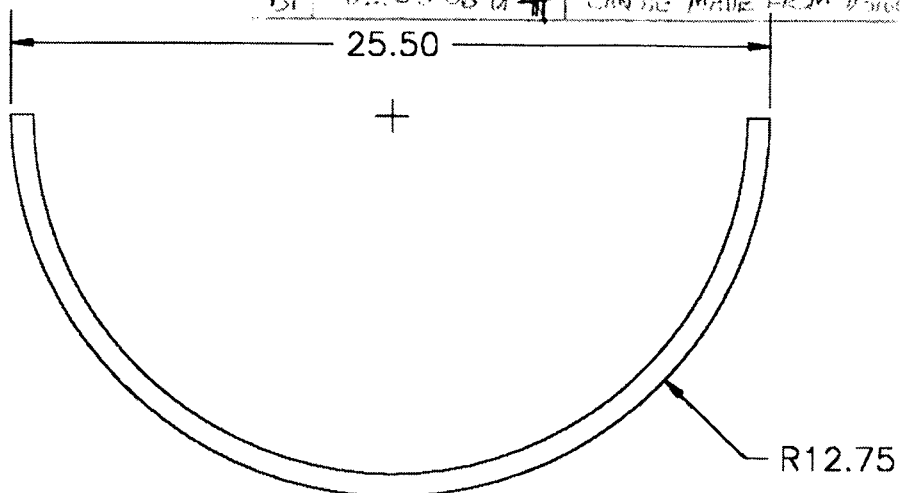
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DART

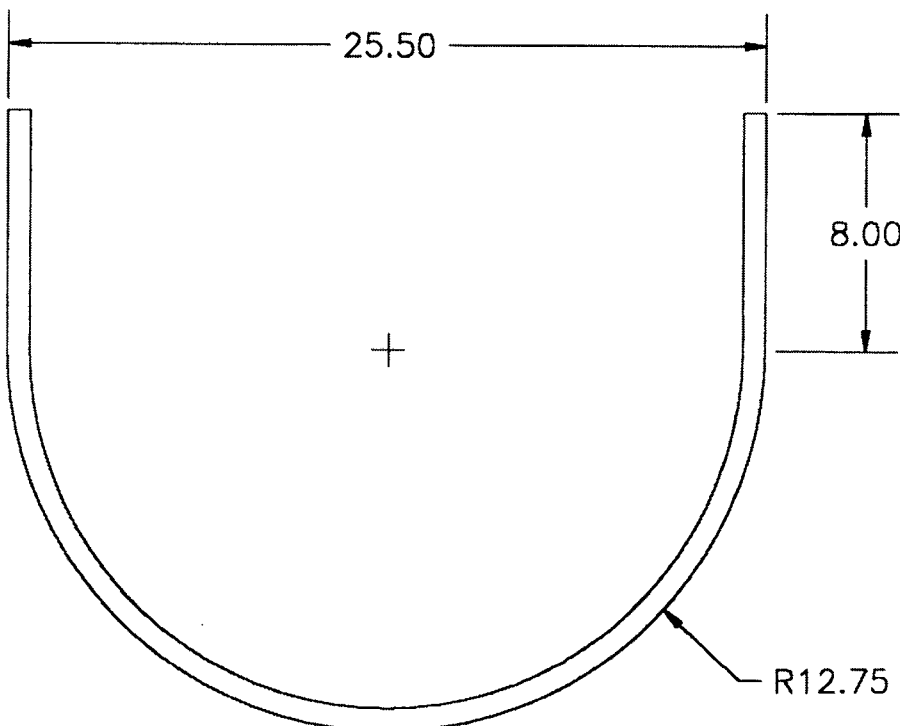


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		


BI 02.03.06 P-# CAN BE MADE FROM D3166-1



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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